

7638



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6796941-17
Job Sheet 181504



SL5
139

0/5

7638
8-31

Part No: RB6796941-17

Job Qty: 8 ea

Part Name: Punch



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 7/29/18

Job Tracking No:

Due Date: 8/2/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB6796941-17 Rev. H IPP Rev. A 18.07.05 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	8/2/18	8/2/18	0.00	0.00	Start Up Machining-4		DAS 56
120	Mori Seiki	8 pcs	8/2/18	8/2/18	0.00	1.33	MORI SL2500Y		9-89
130	QC	8 pcs	8/2/18	8/2/18	0.00	0.00	QC2 Machining-5		
140	QC	8 pcs	8/2/18	8/2/18	0.00	0.00	QC8 Machining-5		B. 18-08-21
170	Outsource	8 pcs	8/2/18	8/2/18	0.00	0.00	Outsource13		CG 18-8-22
180	Packaging	8 pcs	8/2/18	8/2/18	0.00	0.00	Packaging2		AUG 31 2018
190	QC	8 pcs	8/2/18	8/2/18	0.00	0.00	QC6		9-89
200	Packaging	8 pcs	8/2/18	8/2/18	0.00	0.00	Packaging3-2		18-09-06
210	QC21-FG	8 Ea	8/2/18	8/2/18	0.00	0.00	QC21		GA141

Part Op 120 - 1-Machine as per folio FC 304 FOLIO REV: AA

DWG REV: 2-Debur

Descriptions: 140 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

170 - Issue P/O to GROUPE ALTECH: P/O 040807 - Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1144 -Certificate of Conformity is required

180 - Receive

200 - Bag and tag. See note 8.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-1144-R2.000	1144 Steel Proof Round Bar 2.000"	2.7496 ft (.3437 ea) 3.1125 (+390) (-400)	90-Start up Operation	S052 863

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-1144-R2.000	3	18	0



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
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ations

not be found.

Container No: S103413



Part: RB6796941-17

Job No: 181504

Serial No/Batch: S103413

Revision: H

Inspector:

Exp Date:

ht Instructions:

Date: 08/20/18

Plex 7/30/18 12:41 PM dart.logan.david

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date : _____	Step #: _____	QTY Effective : _____			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____						

8 7 6 5 4 3 2 1

D

D

C

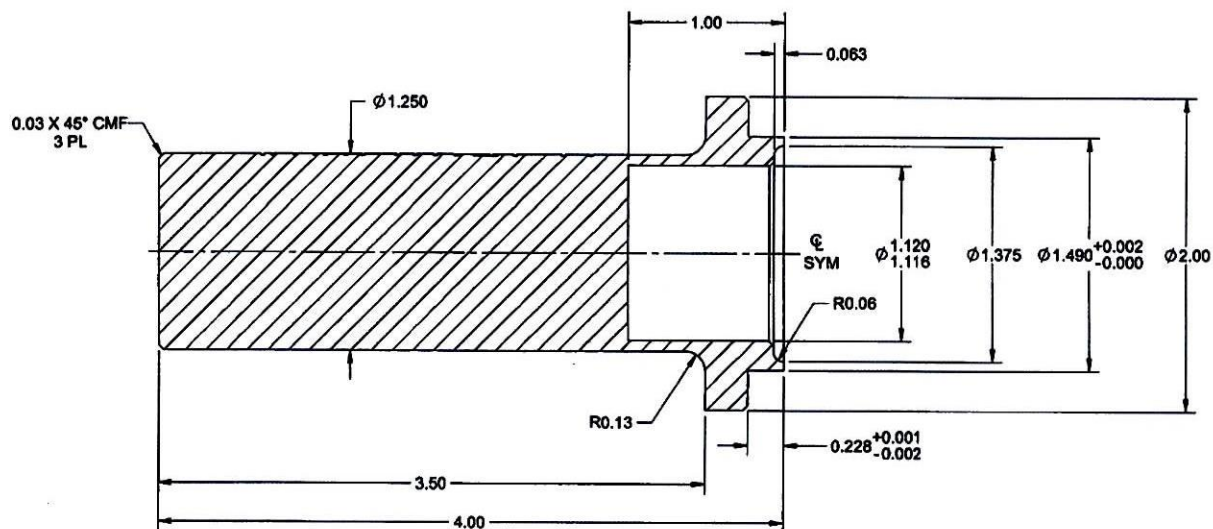
C

B

B

A

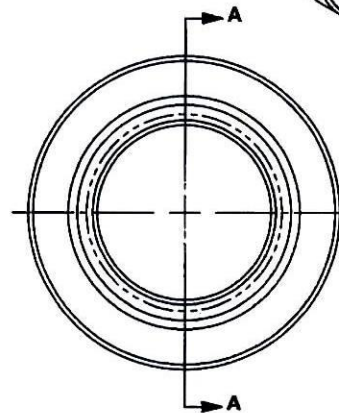
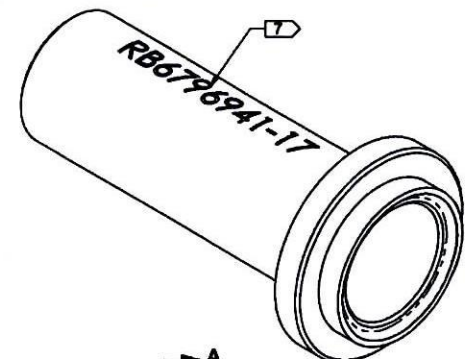
A



SECTION A-A

NOTES:

- 1) MATERIAL: 1144 STRESSPROOF
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN
- 8) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



RB6796941-17 PUNCH

8

H	TEMPLATE UPDATED PER DARTS STANDARDS, FINISH BLACK OXIDE CHANGED FOR ZINC PLATE TYPE II, DIMENSION 1.104 CHANGED FOR 1.118/1.120, REFER TO PREVIOUS REV FOR DETAILS			18-753	VM
REV.	DESCRIPTION			ECN #	BY
DESIGN	VM	DART AEROSPACE LTD			
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA			
CHECKED	MP	TOOL PART #	REV. H		
MFG. APPR.	DP	RB6796941-17	SHEET 1 OF 1		
APPROVED	MP	TITLE	SCALE		
DATE 6/19/2018		PUNCH	NTS		
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8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040807**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040807
PO Date: 8/22/18
Due Date: 8/28/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181505	RB6796941-18	Punch -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1144 -Certificate of Conformity is required	Firmed	-	8/28/18	9 pcs	0 pcs	9 pcs	\$5.29412/pcs	\$47.65
2	181504	RB6796941-17	Punch -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1144 -Certificate of Conformity is required	Firmed	-	8/28/18	8 pcs	0 pcs	8 pcs	\$5.29411765/pcs	\$42.35
3	176987	4.5NR-OH	Nubbins Receiver Hook 1 - Nickel plate .0004-.0006 2 - Bake after plating 3 - Certificate of conformity is required	Firmed	-	8/28/18	13 pcs	0 pcs	13 pcs	\$23.2357143/pcs	\$302.06

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
	176986			Firmed	-	8/28/18	15 pcs	0 pcs	15 pcs	\$23.2357143/pcs	\$348.54
Sub Total:							28	0	28		\$650.60
4	178205	RBEM262V3000101-27	Bent Handle Pin -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	8/28/18	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
5	181657	C10-9-1	Latch -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Certificate of Conformity is required	Firmed	-	8/28/18	15 pcs	0 pcs	15 pcs	\$43.71429/pcs	\$205.71
Line Item Note ** URGENT/SOS/ASAP ** :)											
Grand Total:										\$1,066.31	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/24/18 10:47 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(012065-3)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

012065- 3

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
30-Aug-2018		Aman			040807			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RB6796941-18 Rev.	RB6796941-18 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours TYPE 2 SC2 ASTM B633	ZINC CH	9	9	0	0	0
2	RB6796941-17 Rev.	RB6796941-17 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours TYPE 2 SC2 ASTM B633	ZINC CH	8	8	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.